

# Work Order ID 68357

Tuesday, April 12, 2011 10:10:54 AM



Page 1

Item ID: D3794-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 4/12/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

*H*

Date: 4/10/12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3794	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3794 ☐ Dwg Rev: *A* ☐ Prog Rev: *A* ☐ 2-  
Deburr if necessary

*B11-4-13*

*(26)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*B11-4-13*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*m* *11* *04* *13* *(26)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68357**

Tuesday, April 12, 2011 10:10:54 AM

Page 2

Item ID: D3794-3

Accept

Revision ID:

Item Name: Gasket

Start Date: 4/12/2011 Start Qty: 16.00

Required Date: 4/15/2011 Req'd Qty: 16.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: FD-10

0.00



Packaging

Memo

0.00

Packaging

26 BL 11-4-13

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n 4/14 26

11-04-13  
26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, April 12, 2011 10:11:01 AM

Page 1

Work Order ID: 68357

Parent Item: D3794-3

Parent Item Name: Gasket





Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC  
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	438.7972	1.2828	22.80533	33.5		
NEOPRENE SHEET 0.063 											11-4-13		

Location

Loc Qty

Loc Code

MAT052

438.7972

116832

38.7972

117295

400

117295

(26)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	48357
<b>Description:</b> Gasket		<b>Part Number:</b>	D3794-3
<b>Inspection Dwg:</b> D3794 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.190	✓		V HB67	
0.300 x 0.300	+/-0.010	303x305	✓		V	
1.88	+/-0.030	1.887	✓		V	
4.281	+/-0.010	4.287	✓		T HB61	
6.44	+/-0.030	6.433	✓		T	
6.00	+/-0.030	6.00	✓		T	
6.75	+/-0.030	6.70	✓		T	
2.00	+/-0.030	2.00	✓		T	
4.75	+/-0.030	4.75	✓		T	
9.50	+/-0.030	9.56	✓		T	
14.25	+/-0.030	14.25	✓		T	
17.75	+/-0.030	17.75	✓		T	
26.74	+/-0.030	26.74	✓		T	
29.23	+/-0.030	29.23	✓		T	

<b>Measured by:</b> B	<b>Audited by:</b> MMS	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-4-13	<b>Date:</b> 11-04-13	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	
B	08.10.17	17.75 revised per Dwg Rev. A	KJ/DD	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

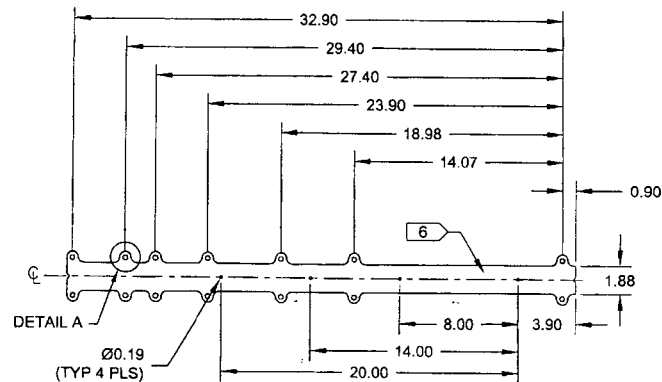
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

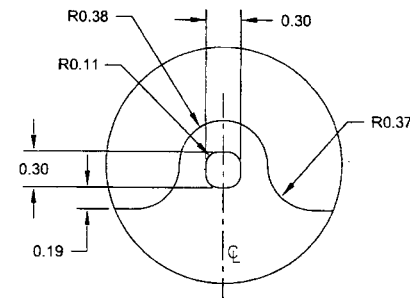
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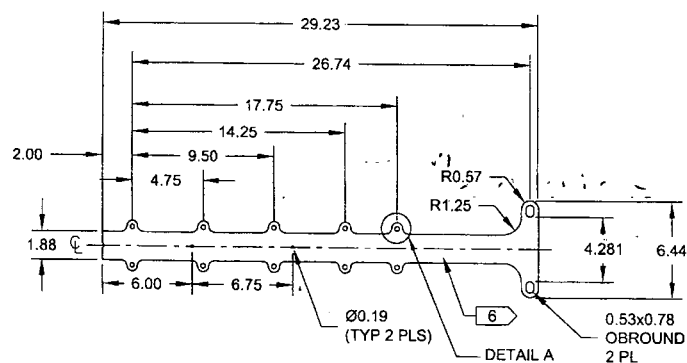




**D3794-1 GASKET**



**DETAIL A**  
SCALE 8X



**D3794-3 GASKET**

**NOTES:**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 68357

*PH11-D412*

**RELEASED**  
*08-05-14*

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION		BY DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3794	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		GASKET.	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC	
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